

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019630**Date Inspected:** 25-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr.Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to the work being performed.

This QA inspector observed the following;

1. INPROCESS:

Bay-14

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the floor beam plate to bottom plate weld joint located on 14W. The weld is designated as SEG3020D-052. The welder is identified as 066038. ZPMC QC Mr. LI MING YANG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2734 R1. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Repair weld for the floor beam plate to bottom plate weld joint located on 14W. The weld is designated as SEG3020E-056. The welder is identified as 066398. ZPMC QC Mr. LI MING YANG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as CWR-2734 R1.

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OBG Trial Assembly

ABF Quality Control (QC) personnel performing D-Scan Ultrasonic Testing (UT) for the side plate to side plate transverse splice weld joint located on 12BW+12CW at cross beam side. The weld is designated as OBW12E-002 & 003.

ABF Quality Control (QC) personnel performing D-Scan Ultrasonic Testing (UT) for the bottom plate to side plate hold back weld joint located on 12BE+12CE at cross beam side. The weld is designated as SEG3002A-001(12BE) & SEG3003A-011(12CE).

ABF Quality Control (QC) personnel performing D-Scan Ultrasonic Testing (UT) for the bottom plate to side plate hold back weld joint located on 12BE+12CE at bike path side. The weld is designated as SEG3002A-004(12BE) & SEG3003A-012(12CE).

ABF Quality Control (QC) personnel performing D-Scan Ultrasonic Testing (UT) for the edge plate to side plate hold back weld joint located on 12BE+12CE at cross beam side. The weld is designated as CA3002A-005(12BE) & CA3004-001(12CE).

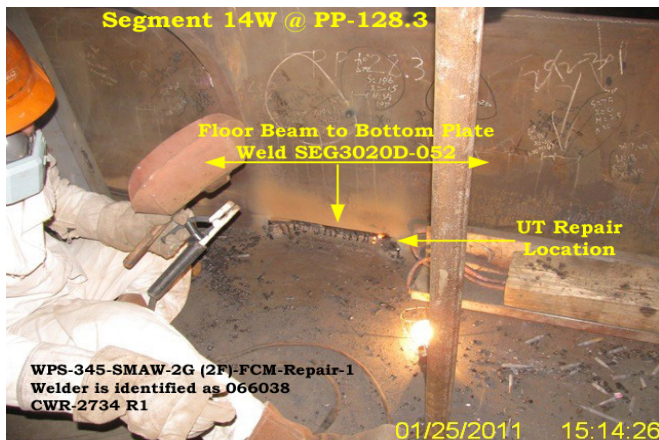
2. NDT:

Ultrasonic Testing (UT) (A, B, C and D-Scan):

UT carried out as per the ABF submitted UT Report.

This QA Inspector performed Ultrasonic testing (UT) 10 % of the area that has been previously tested and accepted by ABF Quality control personnel. This QA inspector generated a UT (TL-6027) report on this date. The members are identified as corner joint between edge plate to side plate hold back weld joint located on 12BE+12CE at bike path side. According to rejection criteria of "D" Scan procedure that Caltrans QA did not find any Rejected indication at scanning area. The Weld Designation is as follows: CA3005-001.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh
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Quality Assurance Inspector

Reviewed By:	Miller,Mark
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QA Reviewer
